

Date: Wednesday, 6/7/2006 11:13:07 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: ROD	
Job Number	: 27447		Part Number	: D3134	
Estimate Number	: 10745		Drawing Number	: D3134 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/7/2006	S.O. No. : N/A	Drawing Revision	: D	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A				
Previous Run	: 24340				
Written By	<u>SEE ARNE USEK & KATE</u>		Due Date	: 6/14/2006	
Checked & Approved By	<u>n 22</u>			Qty:	4 Um: Each
Comment	: Est. A 02.11.12 New issue KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0250W049	304 SS Seamless Tubing	
		Comment: Qty.: 2.3888 f(s)/Unit Total : 9.5550 f(s) 304 SS Seamless Tubing Cut material to length as per template D3134-3/-4T1 Material: AISI 304/316 Annealed SS tubing 0.250OD x 0.049 wall (M304TR0.250W.049) Batch: M100839	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134 Deburr rod, no sharp edges. Bend as per Dwg D3134 using template D3134-4T2	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock Location: CA - 9	
5.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Inspection Level 21	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
06/06/19	2	Scrap one rod Because the Tap tool broke inside the rod	JD 06/06/19	Scrap one and <u>no</u> replace <u>maybe the machine</u> <u>side could make a</u> <u>better job</u>	MJ 06/06/19	✓ 6/6/21	JD 06/06/19	✓ 06/06/21	

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 1Date: 06/06/23

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

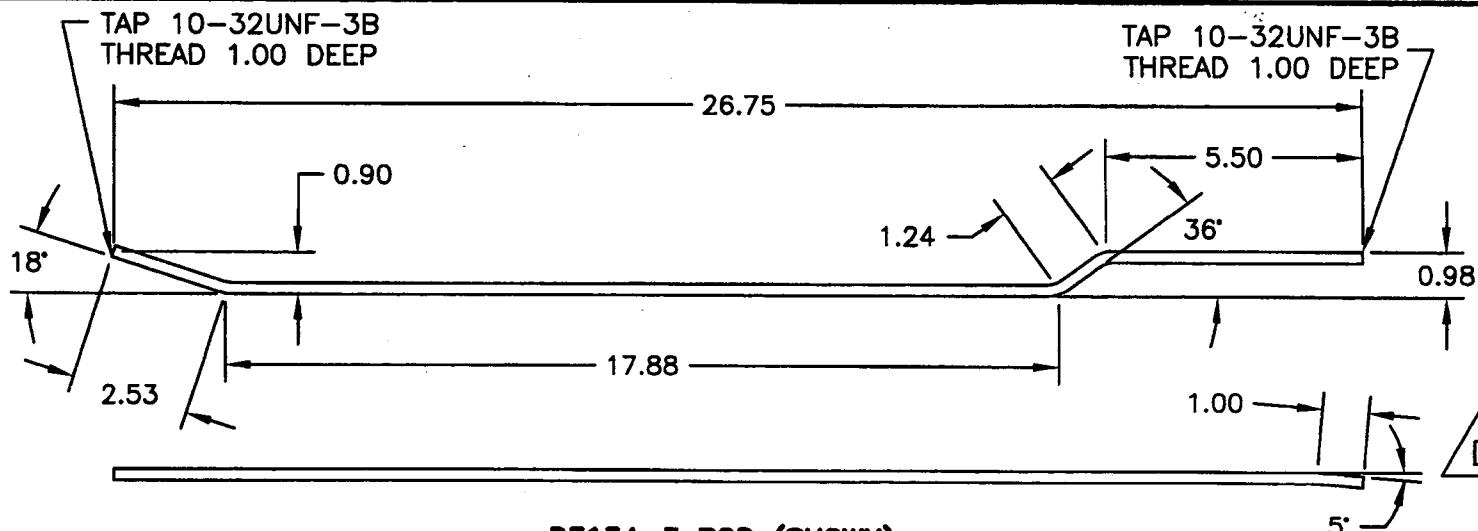
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

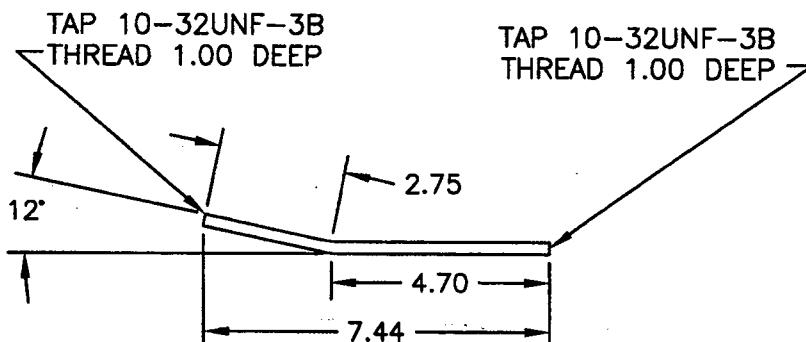
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**D3134-3 ROD (SHOWN)**

(REPLACES PREMIER P/N B30-23000-139)

D3134-4 ROD (OPPOSITE)**D3134-1 ROD**
(REPLACES PREMIER P/N B30-23000-137)NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL
(REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

REFERENCE ONLY

DRAFT AEROSPACE LTD
04-05-04

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D3134	SHEET 1 OF 2
DATE			SCALE
A 06.05.08	<i>[Signature]</i> 02.04.17	NEW ISSUE	NTS
B 06.05.08	<i>[Signature]</i> 02.09.26	ADD "ANNEALED" SPEC; REDESIGNED D3134-1	
C 06.05.08	<i>[Signature]</i> 04.10.18	ADD PART MARKING	
D 06.05.08	<i>[Signature]</i> 05.12.05	CORRECT VIEW	
E 06.05.08	<i>[Signature]</i> 06.05.08	ADD -5, REF DS1 9331	

W/O:		WORK ORDER CHANGES					
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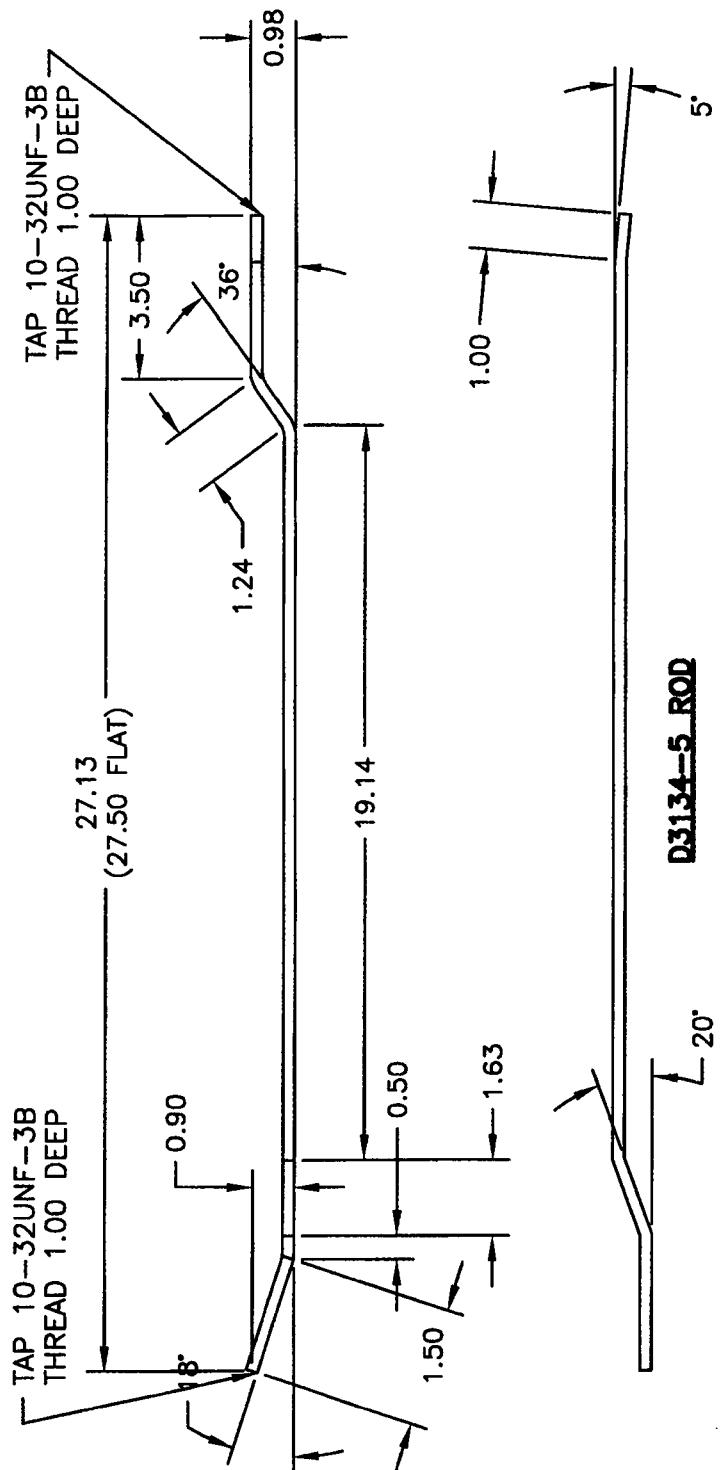
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3134	REV. E SHEET 2 OF 2
DATE 06.05.08	TITLE ROD	SCALE NTS	



RELEASED
06.05.09 *[initials]*

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